

Date: Thursday, 04/09/2008 9:01:45 AM  
User: Julie Lecocq

**Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOOR WINDOW  
Job Number : 41796  
Estimate Number : 10848  
P.O. Number :  
This Issue : 04/09/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D3295041  
Drawing Number : D3295 REV D  
First Issue : / / Type : MACHINED PARTS Project Number : N/A  
Drawing Revision : D  
Previous Run : 39598 Material :  
Due Date : 11/09/2008 Qty: 12 Um: Each  
Written By :  
Checked & Approved By : JUL 08 9.04  
Comment : Est. C 05.06.20 D3295-1 no longer made in-house KJ/JLM  
Est Rev:D Added DT8822 07-03-20 JLM  
Est Rev:E Returned Manufacturing In House 07-06-26 JLM

**Additional Product**

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MLEXS125 9034 01 1/8" 9034 Lexan Sheet



Comment: Qty.: 1.3020 sf(s)/Unit Total : 15.6240 sf(s)

1/8" Thick Lexan 9034 sheet

Batch: 106-103 HB 8-9-4

2.0 WATER JET 173 FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3295

Dwg Rev: D

Prog Rev: D

HB 8-9-4

2-Remove plastic and wrap in saran wrap. HB 8-9-4

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 8-9-4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S & color lot (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3295-041 PAR #: N/A Fault Category: Prod Eng Coordinator NCR: (Yes) No DQA: D Date: 08/09/11  
D350-367-115  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: D Date: 08/09/11

NCR: <u>41796</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/11	#20	Found on all 20 windows that 1 hole is too small R.C. Program was wrong	<u>BS/11/12</u>	Fix Program Drill out hole with correct (0.156") Drill Bit - carefully	<u>BS/11/12</u> 8/9/11	<u>BS/11/12</u>	<u>BS/11/12</u>	<u>BS/11/12</u>

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 41796

Part Number: D3295041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3295.

Put window in plastic wrap.

SAD 08/09/11 (20)

6.0

D27281

Dart Logo Label - small



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Dart Logo label small

Pick:

Qty	Part Number	Description	Batch
1	D2728-1	Decal	39011

SAD 08/09/11

20

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/09/11 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 017

8/9/11

(20)

SAD

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/11

Job Completion



W 08-09-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	41796
<b>Description:</b> Window		<b>Part Number:</b>	D3295
<b>Inspection Dwg:</b> D3295 <b>Rev:</b> D		<b>Page 1 of 1</b>	

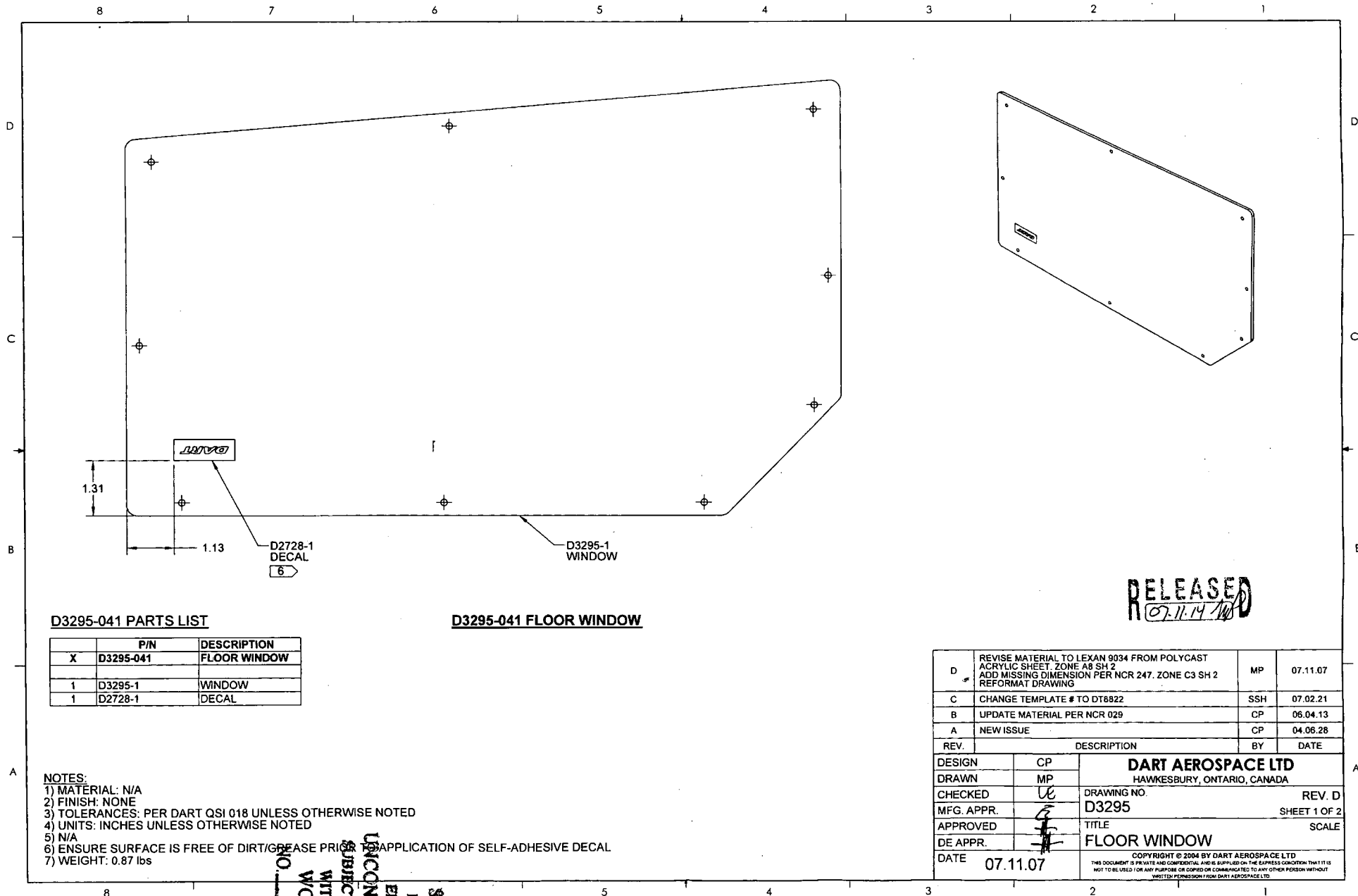
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	.160	x			
17.13	+/-0.030	17.13	x			
10.43	+/-0.030	10.43	x			
14.35	+/-0.030	14.35	x			
8.98	+/-0.030	8.98	x			
0.625	+/-0.010	.618	x			
7.109	+/-0.010	7.106	x			
15.845	+/-0.010	15.850	x			
2.308	+/-0.010	2.310	x			
5.420	+/-0.010	5.425	x			
9.402	+/-0.010	9.402	x			
1.312	+/-0.010	1.310	x			
6.260	+/-0.010	6.254	x			
12.520	+/-0.010	12.520	x			
0.313	+/-0.010	.313	x			
3.750	+/-0.010	3.750	x			
8.150	+/-0.010	8.150	x			
9.006	+/-0.010	9.001	x			
0.125	+/-0.010	.119	x			

<b>Measured by:</b> HB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-9-4	<b>Date:</b> 08/09/14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue      P/O D3295-041	KJ/EC/DD [Signature]	[Signature]



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